

Work Order ID 68297

Monday, April 11, 2011 1:19:43 PM

Page 1

Item ID: D4154-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate Assembly

Start Date: 4/11/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date: 11-01-11

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

A1110 B

0.00

100

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154
2059 B Hardcoat Welding Rod
BATCH# M117609

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154
304 S.S. Welding Rod
BATCH # M1707057

3-Transfer drill holes in bar

4- Use D19684 to check fit after welding

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

11-5-18 (14)

11.05.18 (4)

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Page 2

Item ID: D4154-041

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Setup Start

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Item Name: Wearplate Assembly

Start Date: 4/11/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11.05.18 (4)

130

Grey Sandtex(Ref 4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:15
OVEN TEMPERATURE: 300°
FINISH TIME: 9:15

11-5-19

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 of 11 4/10/19

Work Order ID 68297

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Page 3

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 4/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150



Small Fab

Memo

0.00

0.00

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3 dwg D4154.

25 11-05-19

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/19

X4

170



Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

FP-9

X4 11-05-19

Work Order ID 68297

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Page 4

Item ID: D4154-041

Accept

Revision ID:

Item Name: Wearplate Assembly

Start Date: 4/11/2011 Start Qty: 6.00

Required Date: 4/15/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup



Stop



Cust Item ID:

Customer:



11/5/2011

11-05-19

Picklist Print

Monday, April 11, 2011 1:19:49 PM

Page 1

Work Order ID: 68297

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A 10.09.21 new issue DD ver: EC
10.11.04 added DT9684 DD ver: EC

IPP Rev: B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1

Manufactured

No

100

Each

1.0000

6



Plate

68302 x4

Location

Loc Qty

Loc Code

WA

1

66312

1

D4155-1

Manufactured

No

100

Each

0.0000

6



Bar

B66174 x4



EL

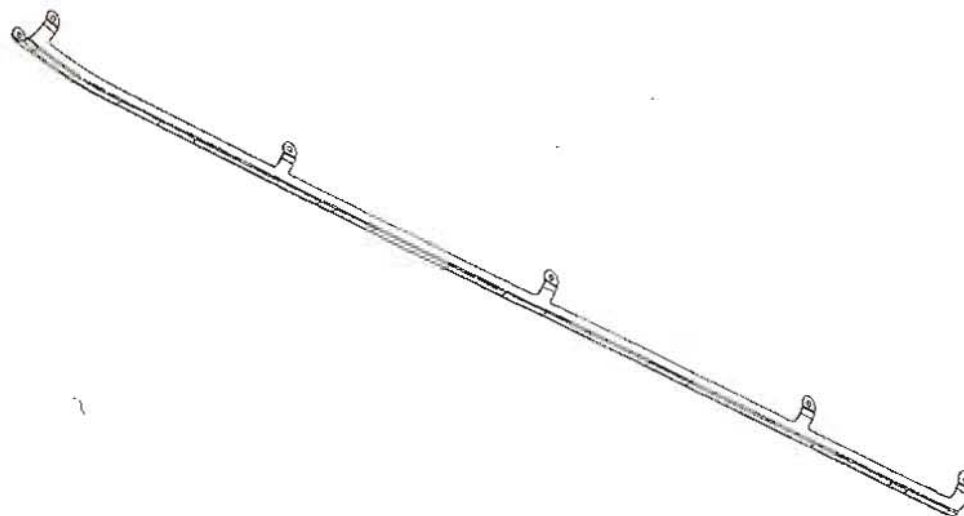
11-5-18



EL

11-5-18

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	AR	2069B	W/COAT
4	AR	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

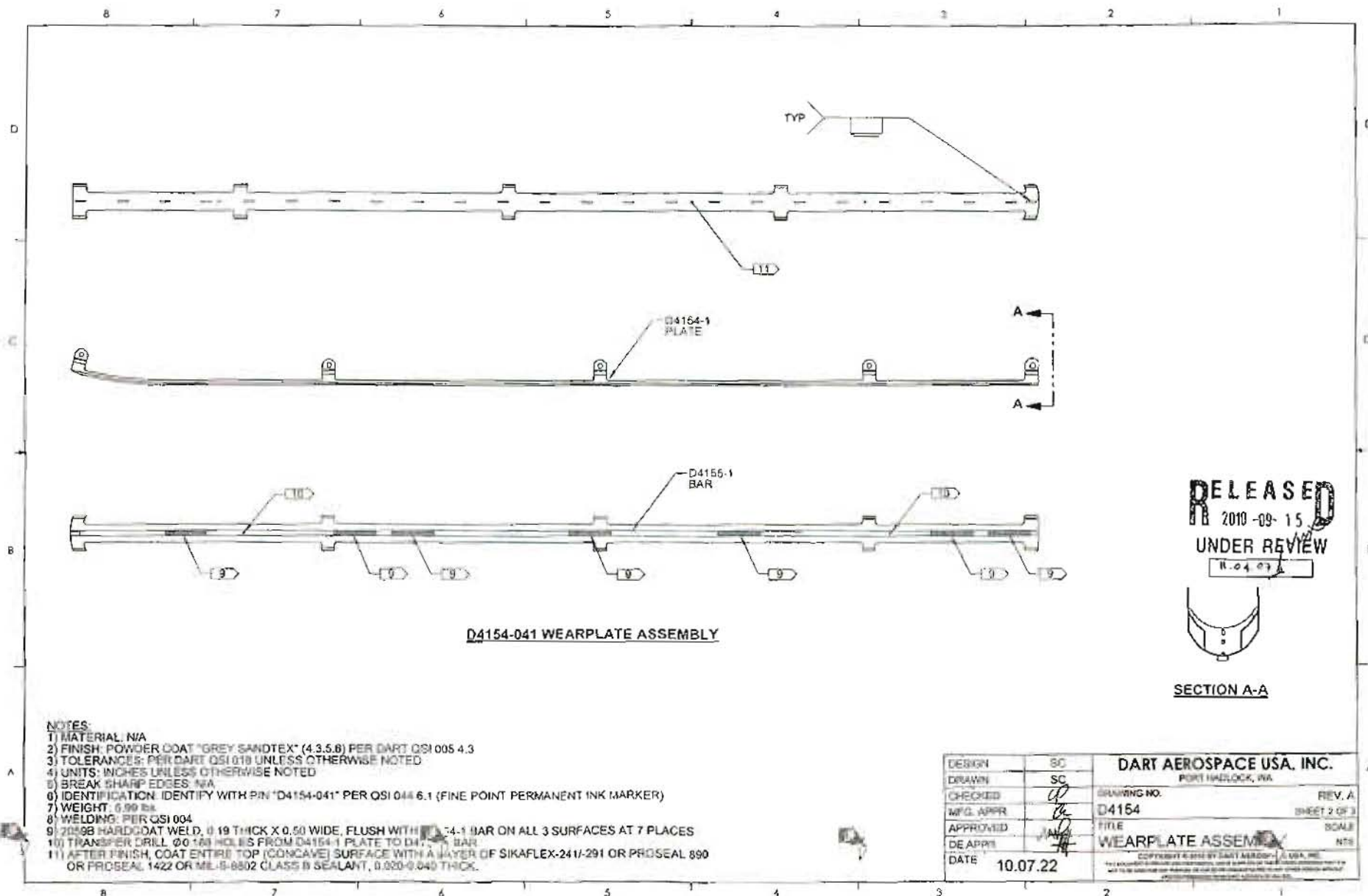


D4154-041 WEARPLATE ASSEMBLY

RELEASED
 2010-09-15
UNDER REVIEW
 J. D. C.
 PAR 11-72

A. NEW ISSUE		ISC	10.07.22
REV	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED			
MFG APPR			
APPROVED			
QC APPR			
DATE	10.07.22		

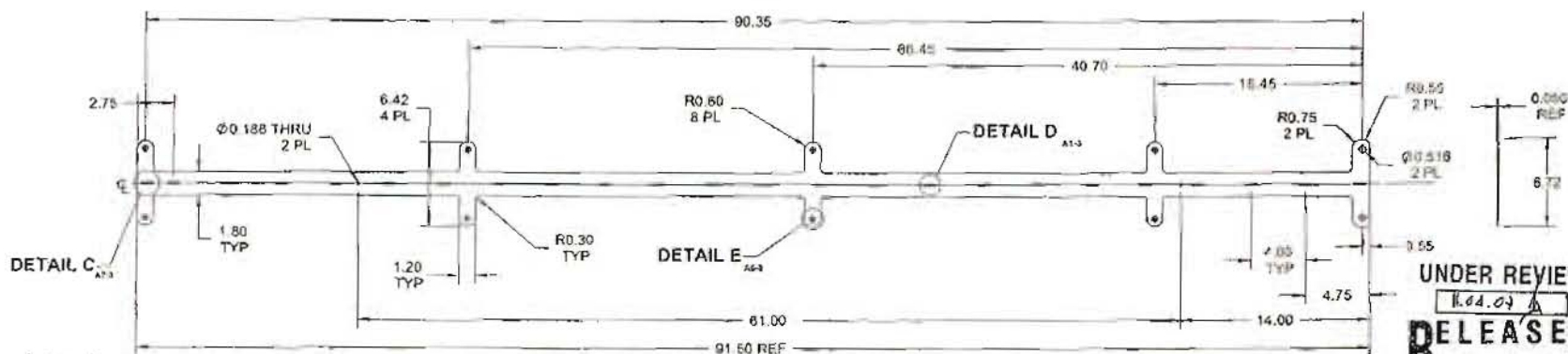
DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO	REV. A
D4154	SHEET 1 OF 3
TITLE	SCALE
WEARPLATE ASSEMBLY	NTS
COPYRIGHT © 1986 BY DART AEROSPACE USA, INC.	



1.29
R31.7
REF

82.54

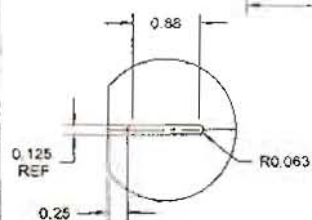
D4154-1 PLATE
(MAKE FROM D4154-1F)



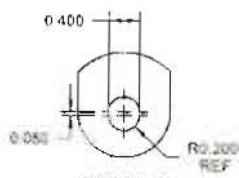
UNDER REVIEW

RELEASED
2010-09-15

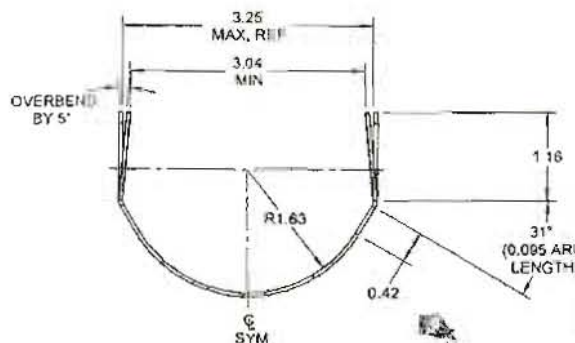
D4154-1F FLAT PATTERN



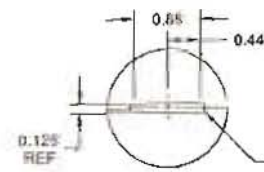
DETAIL C
SLOT DETAIL TYP



DETAIL E
SLOT DETAIL TYP



SECTION B-B



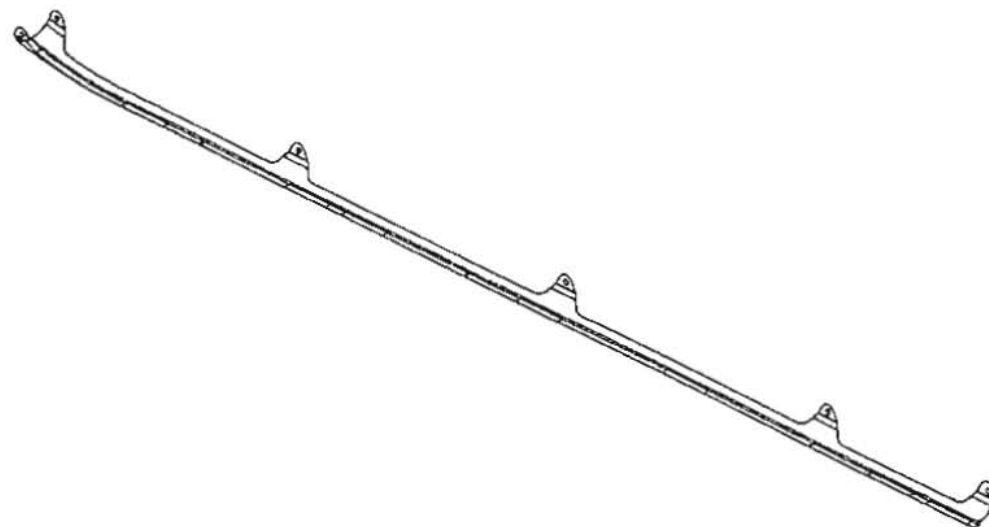
DETAIL D
SLOT DETAIL TYP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 16 GAUGE 0.050 THICK, (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.71 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, VA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR		D4154	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR		WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	

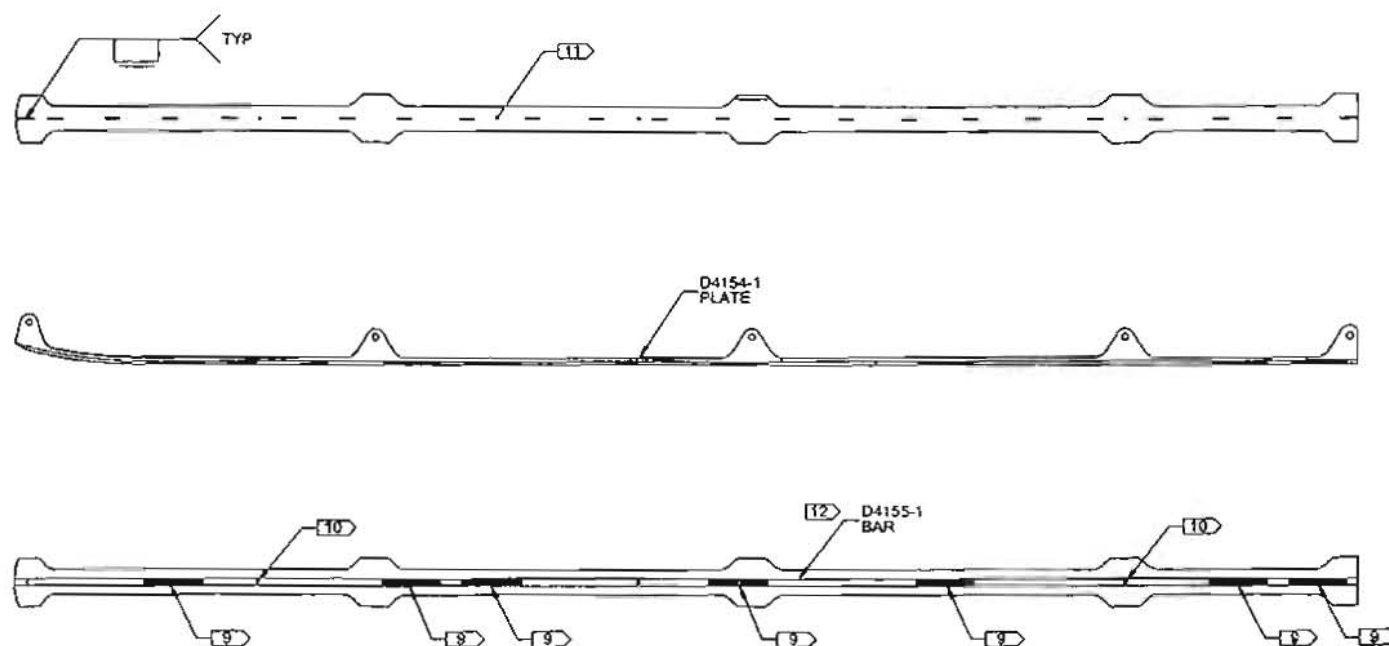
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2050B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13
JMT

B	ITEM 4 WAS PR1422 (D3-1) REMOVED FINISH TO NOTE 2 (A3-2). REMOVED SECTION A-A (NO LONGER REQUIRED). REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SE	DRAWING NO.	REV. B
CHECKED	SE	D4154	SHEET 1 OF 3
MFG. APPR.	SE	TITLE	SCALE
APPROVED	SE	WEARPLATE ASSEMBLY	NTS
DE APPR.	SE	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.	
DATE	11.04.05		



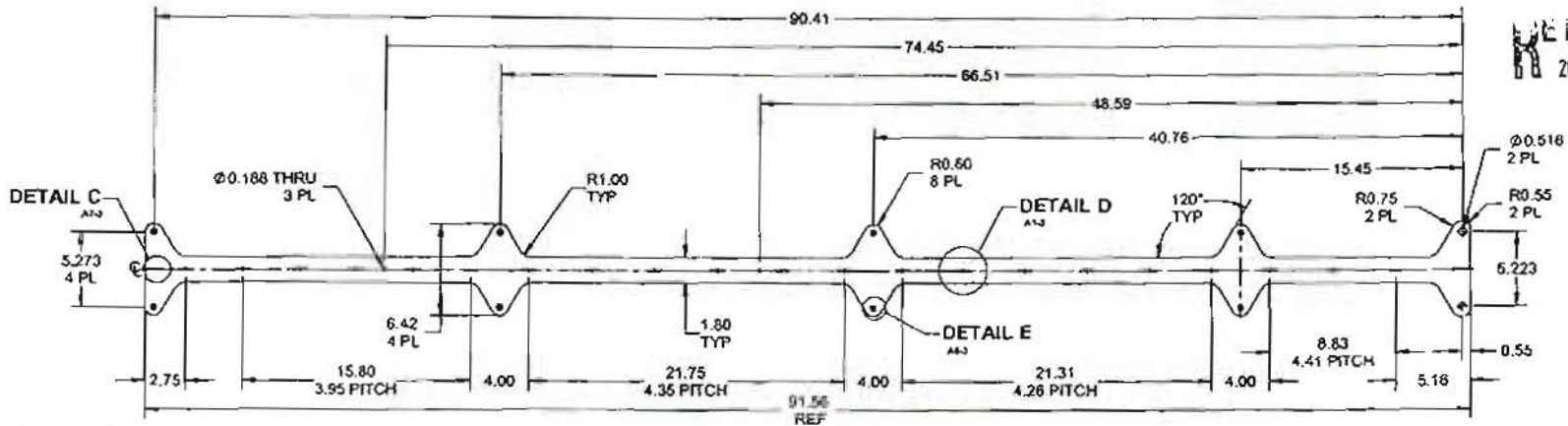
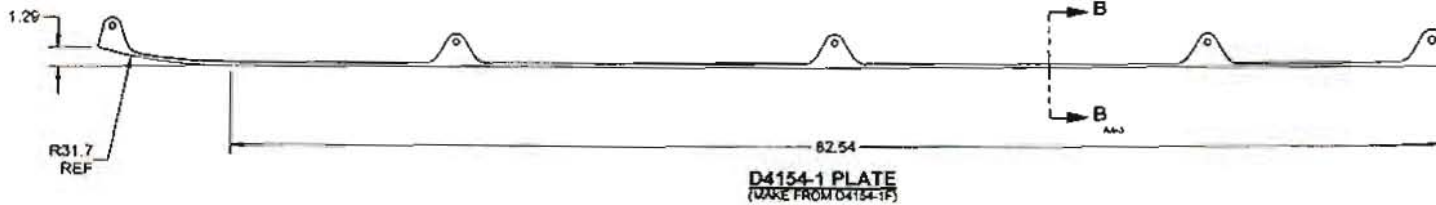
D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

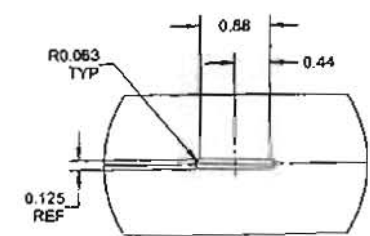
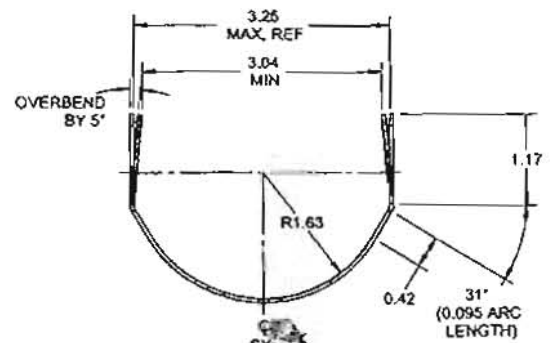
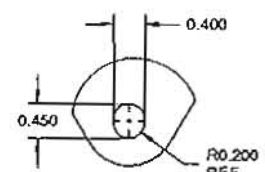
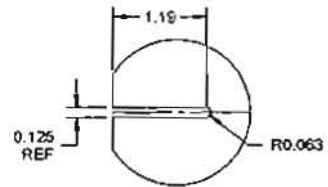
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 Lbs
- 8) WELDING: PER QSI 004
- 9) 2050B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, WELD WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	7	DRAWING NO.	REV. B
MFG. APPR.	11	D4154	SHEET 2 OF 3
APPROVED	11	TITLE	SCALE
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DATE	11.04.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	



RELEASED
2011-04-13



- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 16 GAUGE 0.050 THICK (REF. DART SPEC. M304S16GA)
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 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, VA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RPLATE ASSEMBLY	NTS
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